

Date: Friday, 8/3/2007 9:25:53 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 33829		
Estimate Number	: 11168		
P.O. Number	: N/A	Part Number	: D22823
This Issue	: 8/3/2007 S.O. No. : N/A	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 8/3/2007 Type MACHINED PARTS	Drawing Revision	: E
Previous Run	: 33415	Material	: N/A
Written By	: <u>Jul 07-08-03</u>	Due Date	: 8/10/2007
Checked & Approved By	:	Qty:	60 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM		

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 M304TR0675W091 304 RD Tube .675 x .091W



Comment: Qty.: 0.2078 f(s)/Unit Total : 12.4677 f(s)
 Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness
 (M304TR0.675W.091)
 Batch M10522#3 SB/RP 07/08/03

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

DT 07/08/04 (81)

INSPECT PARTS AS THEY COME OFF MACHINE

DT 07/08/04 (81)

3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SB/RP 07/08/03 (35)

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 07/08/04

116

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: LF

Jul 07-08-06 (116)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 33829

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



116

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/08

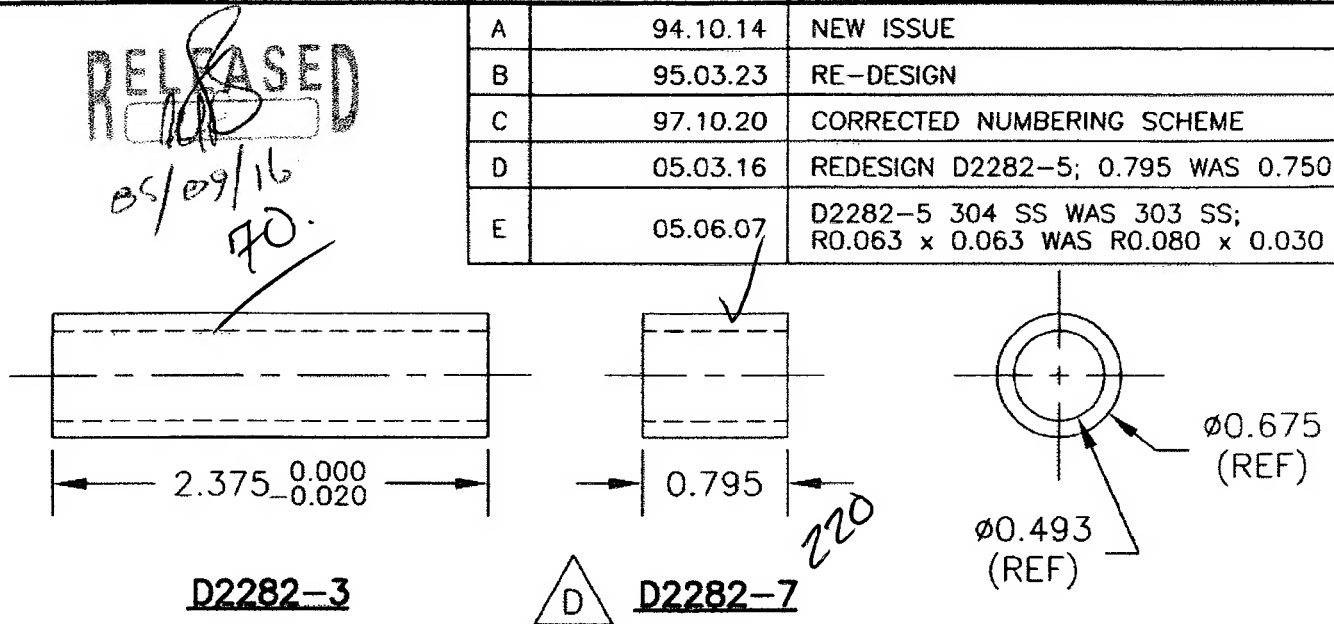
Job Completion



C 207/08/08

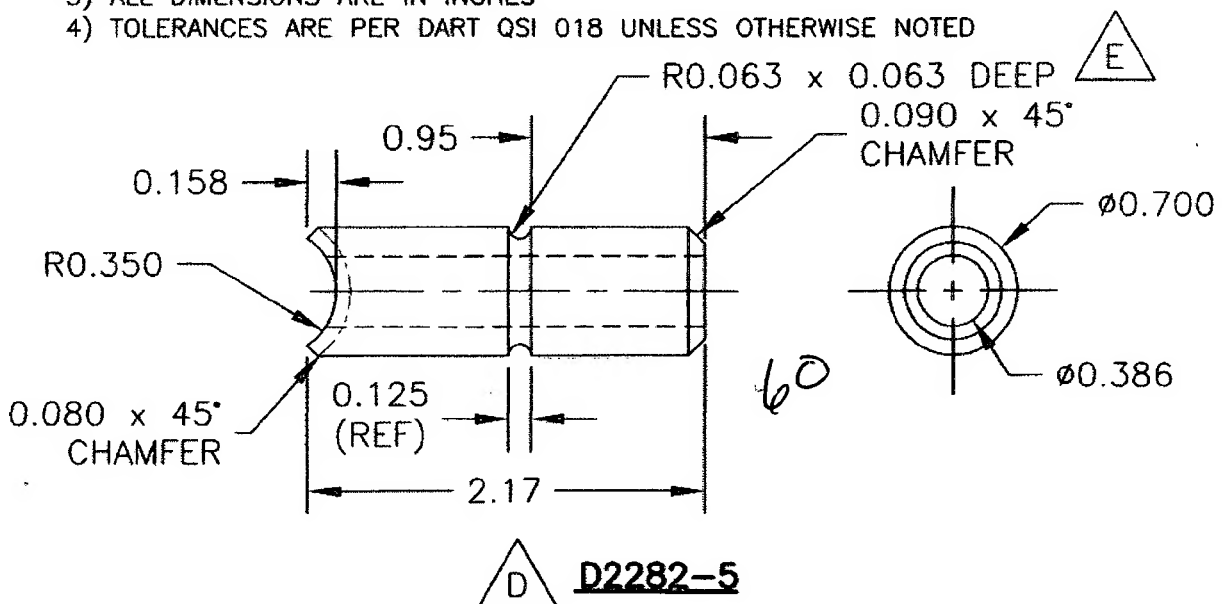


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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